



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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RBE350A93-3305-20-1

Job Sheet 197356



Part No: RBE350A93-3305-20-1

Job Qty: 12 pcs

Part Name: Tail Gearbox Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3305-20-1 REV:C IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	12 pcs	9/2/19	9/2/19	0.50	12.00	SL-2500Y - 1		SL 19-11-14
120	QC 2	12 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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130 QC 8	12 pcs	9/2/19	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	OK 19/11/05
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
230 Packaging 3-1 - Stock - B4B	12 pcs	9/2/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	OK 2 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

7/4/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
240 QC 21 - SA	12 pcs	9/2/19	0.00	0.00	QC 21 - SA - 21	NOV 08 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per folio FB876 FOLIO REV: AA DWG REV: C
 Descriptions: 2-Broach as per dwg. 3-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 230 - (Identify as per dwg & Stock Location:)
 240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.375	17-4 SS H900 Round Bar 1.375"	1.3920 ft (.116 ea)	100-SL-2500Y - 1	S207999

Job Allocations

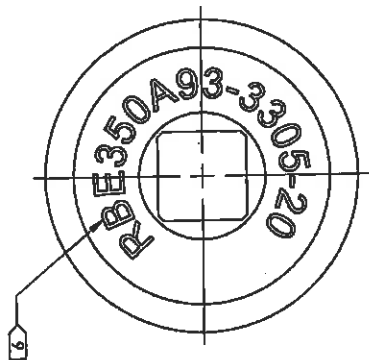
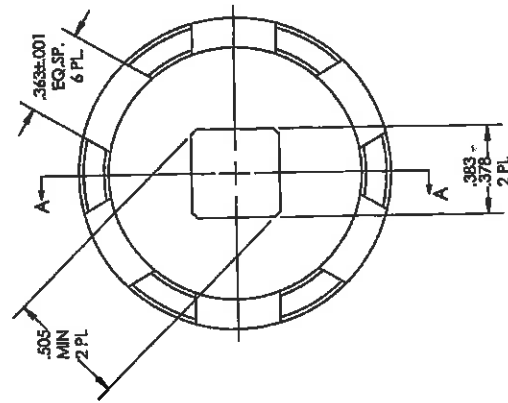
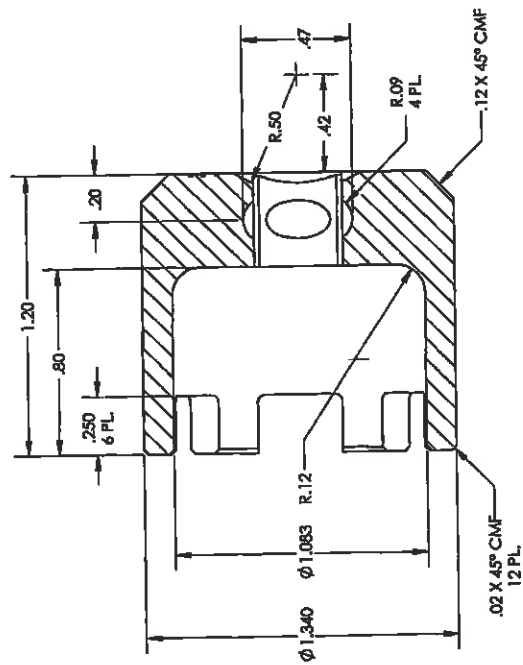
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M17-4-H900-R1.375	1	9	0

Part Specifications

Specifications could not be found.

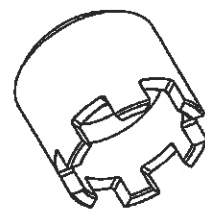
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	PART NUMBER -1 ADDED AT THE END, TOLERANCE ON DIMENSION .263" CHANGED FOR .263" ±.001" ENGRAVING CHANGED FROM MACHINE TO ORGAVE, VIEWS CHANGED FOR CLARITY	17-796	17.12.21	VM	ML



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197326
ML
190705



- NOTES:
- 1) MATERIAL: 17-4 PH-H900 SS
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, 0.010" DEEP

PART AEROSPACE		Headquarters, Ontario, Canada																	
TAIL GEARBOX WRENCH																			
PART NO.	RBE350A93-3305-20-1	REV	C																
<table border="1"> <tr> <td>DATE</td> <td>17.12.21</td> <td>BY</td> <td>VM</td> </tr> <tr> <td>ENGR</td> <td>17.12.21</td> <td>BY</td> <td>ML</td> </tr> <tr> <td>CHECKED</td> <td>17.12.21</td> <td>BY</td> <td>ML</td> </tr> <tr> <td>APPROVED</td> <td>17.12.21</td> <td>BY</td> <td>ML</td> </tr> </table>				DATE	17.12.21	BY	VM	ENGR	17.12.21	BY	ML	CHECKED	17.12.21	BY	ML	APPROVED	17.12.21	BY	ML
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RBE350A93-3305-20-1 TAIL GEARBOX WRENCH

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

NCR No.		Job: _____		Part No. _____		Date: _____		Sequence #: _____		QTY Affected: _____		MRRB (QS1042)	
DISPOSITION		DEPARTMENT/PROCESS		Cross tube		Eng. (Non-AW)		Engineering		Water Jet		Supplier Quality	
Rework		Skid-tube		Small Fab		Prod. Eng. Coord.		Rec/Store/Packaging		Finishing			
Scrap		Machining		Large Fab									
Use-as-is													
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor		QC / QA Coordinator					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							

